



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5634-041
Job Sheet 197988



Part No: D5634-041

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Due Date: 8/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5634 REV.A IPP REV:A 19.01.17 NEW ISSUE DD VERF:JFS IPP Rev:B A13 19.01.31 drawing
revision DP Verify DD IPP Rev:C 19.03.11 as per dwg A14 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	1 pcs	8/8/19		0.00	2.17	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		MGG
							Skidtubes - 5		TF
							Skidtubes - 6		BE
							Skidtubes - 7		
110	QC 5	1 pcs	8/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		SEP 17 2019
							QC 5 - 9		DAS
							QC 5 - 50		CC
							QC 5 - 30		9-89
							QC 5 - 40		
115	QC 10	1 pcs	8/8/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		DAS
							QC 10 - 24		24
							QC 10 - 43		9-89

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120 Handfinish - 1-1 Chemical-B4B	1 pcs	8/8/19	0.00 0.25	QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	A SEP 18 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	8/8/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
140 Skidtubes - 2 - B4B	1 pcs	8/8/19	0.00 0.25	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MGA TF
				Skidtubes - 4 - B4B	

				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 5	1 pcs	8/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				160 Skidtubes - Bend - 2 - B4B	1 pcs
170 QC 5	1 pcs	8/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE/TW
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				180 Skidtubes - 4 - B4B	1 pcs
Skidtubes - 2 - B4B					
Skidtubes - 3 - B4B					
Skidtubes - 4 - B4B	TF				
Skidtubes - 5 - B4B	BE				
Skidtubes - 6 - B4B					
Skidtubes - 7 - B4B					
195 QC 5	1 pcs	8/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				Plex 7/19/19 11:17 AM Dart.lajeunesse.marie	

						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	SEP 25 2019
						QC 5 - 9	DAS 68
						QC 5 - 50	9-89
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
200 Handfinish - 1-2- Chemical-B4B	1 pcs	8/8/19	0.00	0.25		Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	SEP 26 2019
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
210 Spray Paint - 2 - B4B	1 pcs	8/8/19	0.00	0.50		Spray Paint - 1 - B4B	
						Spray Paint - 2 - B4B	RD 19-9-23
						Spray Paint - 3 - B4B	
						Spray Paint - 4 - B4B	
220 QC 14	1 pcs	8/8/19	0.00	0.00		QC 14 - 15	ML 19-10-03
						QC 14 - 2	
						QC 14 - 34	
						QC 14 - 41	
						QC 14 - 51	
						QC 14 - 58	
						QC 14 - 59	
						QC 14 - 9	
						QC 14 - 68	
						QC 14 - 40	
						QC 14 - 19	
						QC 14 - 43	
						QC 14 - 24	
						QC 14 - 61	
						QC 14 - 81	
230 Handfinish - 4-2-Assembly-B4B	1 pcs	8/8/19	0.00	0.50		Handfinish - 4 - 1 - B4B	ML 19-10-07
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	

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240 QC 5	1 pcs	8/8/19	0.00 0.00	Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
250 Packaging 3-1 - Stock - B4B	1 pcs	8/8/19	0.00 0.00	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

DAS
40
9-89
OCT 04 2019

DAS
78
9-89

10/7/2019

270 QC 21 - FG	1 pcs	8/8/19	0.00 0.00	Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - FG - 21	OCT 07 2019
				QC 21 - FG - 70	21
				QC 21 - SA - 53	21

Part Op 100 - ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- Remove fwd indexing ridge as per dwg D5634. Descriptions: Notch FWD skid thru back wall only as per section E-E. Prepare for welding 2- Weld fwd cap as per dwg D5634 and QSI004 AR Aluminum Rod Batch: 139071 3- Cut AFT end of tube at 144.0" as per dwg D5634 and deburr end. 4-Drill Aft cap pilot hole using DT8025. 5-Cleco DT8025 in position and install pilot hole drill Jig DT10533. Drill 3/16" pilot holes as per Dwg D5634-041 6-Remove inner indexing ridge on aft end of skidtube as per Dwg D5634 scribe batch # 7-Open aft end cap holes to Ø0.208" as per Dwg D5634. C'sink holes as per dwg. Deburr aft end. 8-Open cross bolt spacer holes as per DWG section C-C AND B-B and deburr as per QSI 018. 9- C'sink crossbolt spacers holes for welding only on section B-B as per dwg

110 - QC5- Inspect part completeness to step on W/O
 115 - QC10- Inspect visual per QSI004- ground welds
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - QC7-Inspect Chemical Conversion Coat
 140 - 1-Bond D5636-041 web in place as per QSI 015. Ensure holes line up Allow 12 Hrs. cure time before cutting Start Date: Sept 19 10:45pm Finish Date: Sept 18, 19 10:45pm
 150 - QC5- Inspect part completeness to step on W/O
 160 - 1-Bend AFT end of tube using bend prog. D5634 AFT as per dwg D5634. Install drop pins in crossbolt spacer holes to maintain web position.
 170 - QC5- Inspect part completeness to step on W/O
 180 - 1- Weld D3275-1 Spacers as per dwg Aluminum rod Batch: 138789 2- Grind weld flush as per dwg
 3- Insert D4720-1 Spacer. Swage as per section B-B QSI 002. Trim and grind flush per QSI 002
 195 - QC5- Inspect part completeness to step on W/O
 200 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch
 210 - PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 5200299 PAINT GLOSS
 BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: 5210553
 220 - QC14- Inspect Spray Paint
 230 - 1-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. 2- Wing Walk tube as per dwg.
 Batch: _____
 240 - QC5- Inspect part completeness to step on W/O
 250 - Identify as per dwg & Stock Location: _____
 270 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5633-1	CAP	1 pcs (1 ea)	100-Skidtubes - 1	<u>5212256</u>
D5634-041BENT	Float Skidtube Assembly, Bent	1 pcs (1 ea)	100-Skidtubes - 1	<u>5212350</u>
D5636-041	Float Web Assembly	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	<u>5213214</u>
D3275-1	Cross Bolt Spacer	7 pcs (7 ea)	180-Skidtubes - 4 - B4B	<u>5199330</u>
D4720-1	Spacer	<u>2423</u> pcs (23 ea)	180-Skidtubes - 4 - B4B	<u>5214318</u>
D2646	Aft Cap	1 pcs (1 ea)	230-Handfinish - 4-2-Assembly-B4B	<u>5215781</u>
MS24693-C272	Screw	2 Ea (2 ea)	230-Handfinish - 4-2-Assembly-B4B	<u>F17137</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D5633-1	1	0	0
	D5634-041BENT	1	0	0
140-Skidtubes - 2 - B4B	D5636-041	1	0	0
180-Skidtubes - 4 - B4B	D3275-1	7	44	0
	D4720-1	23	21	0
230-Handfinish - 4-2-Assembly-B4B	D2646	1	75	0
	MS24693-C272	2	915	0

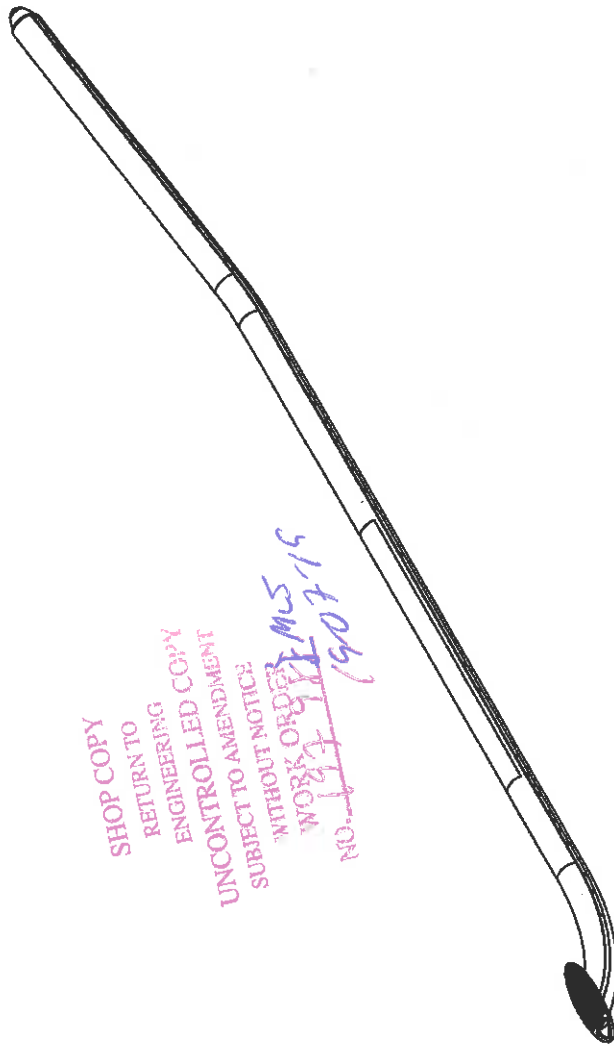
Part Specifications

Specifications could not be found.

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QTY	PART NUMBER	DESCRIPTION
X	D6634-041	FLOAT SKIDTUBE ASSEMBLY
1	D2646	AFT CAP
7	D4275-1	SPACER
23	D4720-1	SPACER
1	D6633-1	TOW STEP
1	D6634-1	FLOAT SKIDTUBE
1	D6636-041	FLOAT WEB ASSEMBLY
2	M624693-C272	SCREW, CSK 100°

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197-187 MS-15
1907-15



D5634-041 FLOAT SKIDTUBE ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT GLOSS BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.4 ON INNER TUBE SURFACE AT AFT END.
 - 7) WEIGHT: 21.03 lb
 - 8) SEAL MATING SURFACES WITH SIKAFLEX -241/-281 OR PROSEAL P/S 880/1422 OR MIL-S-8802 CLASS B2 SEALANT
 - 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-281 OR PROSEAL P/S 880/1422 OR MIL-S-8802 CLASS B2 SEALANT
 - 10) INSTALL WEB INTO OUTER TUBE WITH SIKAFLEX -241/-281 ADHESIVE PER DART QSI 015.
 - 11) LOCATE AS SHOWN, ENSURE DOUBLER END IS LOCATED AT AFT BEND REGION
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5" ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
 - 12) WELDING PER QSI 004.
 - 13) IT IS PERMISSIBLE TO GRIND SKIDTUBE TO IMPROVE FIT WITH TOW STEP. DIMENSIONS SHOWN AFTER GRINDING FOR TOW STEP.
 - 14) SLOT FOR D5633-1 TOW STEP THRU BACK WALL ONLY.

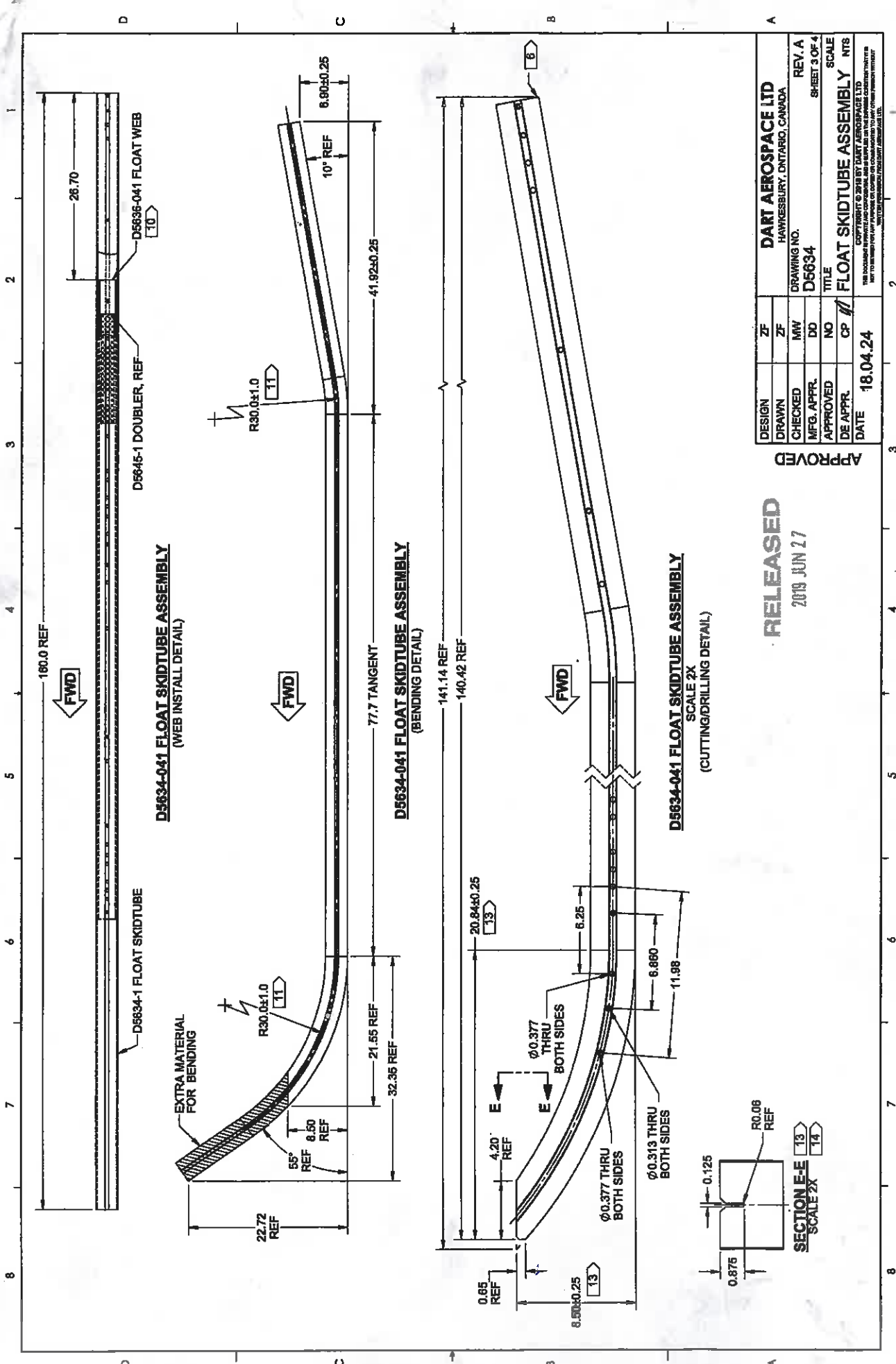
RELEASED

2018 JUN 27
EAM M-746

APPROVED

REV. A	NEW ISSUE	DESCRIPTION	ZF	BY	DATE
DESIGN					
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	18.04.24				

DART AEROSPACE LTD	REV. A
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	
D5634	
TITLE	
FLOAT SKIDTUBE ASSEMBLY	
SCALE	
NTS	
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DESIGN	ZF	ZF	DART AEROSPACE LTD
DRAWN	ZF	ZF	HAWKESBURY, ONTARIO, CANADA
CHECKED	MW	MW	DRAWING NO.
MFG. APPR.	DO	DO	D5634
APPROVED	NO	NO	TITLE
DE APPR.	CP	CP	SCALE
DATE	18.04.24	18.04.24	DATE

APPROVED

RELEASED

2019 JUN 27

2063

DESIGN	ZF	ZF	DART AEROSPACE LTD
DRAWN	ZF	ZF	HAWKESBURY, ONTARIO, CANADA
CHECKED	MW	MW	DRAWING NO.
MFG. APPR.	DO	DO	D5634
APPROVED	NO	NO	TITLE
DE APPR.	CP	CP	SCALE
DATE	18.04.24	18.04.24	DATE

SECTION E-E

SCALE 2X

13

14

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality	DEPARTMENT/PROCESS	Date: _____ Sequence #: _____ QTY Affected: _____ MRB (QSI042)	Completed By Lead hand / Supervisor QC / QA Coordinator						
Description Work Order Deviation		Disposition 								
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function </td> <td style="width:33%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____ </td> <td style="width:33%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up </td> </tr> <tr> <td style="vertical-align: top;"> Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread </td> <td colspan="2"></td> </tr> </table>			Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up								
Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread										